

Work Order ID 51045

July 30, 2009 8:31:16 AM

Page 1

Item ID: D350-588-011

Accept

Setup Start

Revision ID: N/A

Stop

Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/21/09 Start Qty: 4.00

Cust Item ID:

Required Date: 7/21/09 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev N/A

100 0.00



DC

Document Control

DOCUMENT CONTROL

Memo *9/8/12*
Photocopy bluefile and create labels per PPP D350-588-011 CHG002

8 02/08/07

110 0.00



Packaging

Packaging

Pick Kit

Memo

0.00

9/8/12 (TV) SP

120 0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

=) 8 09/08/07

(+4) f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-588-011								
	Location: <u>22</u>								
	PPP Rev: <u>C</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

9/8/07 40 J

09/08/31 J

PL 09-8-27

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Picklist Print

July 30, 2009 8:31:15 AM

Work Order ID: 51045

Parent Item: D350-588-011RevN/A

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 7/21/09

Required Date: 7/21/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN526C1032R7 *K2* Purchased No

120

Each

66.0000

8.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

66

104394

4

110715

62

120

Each

132.0000

32.0000

AN526C832R8 *tg*

Purchased

No



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

132

108335

1

111900

131

110715 SP

111900 9/8/09 74

Dart Aerospace Ltd

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AN526C832R9 <i>75</i>		Purchased	No			120	Each	230.0000	32.0000			
<i>S</i> <i>74</i>												
Screw												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	230	
107376	51	
108377	5	
108928	14	
110372	8	
110915	1	
111916	151	

AN960JD10 <i>74</i>		Purchased	No			120	Each	1,879.000	16.0000			
<i>S</i> <i>74</i>												
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1879	
105442	95	
109059	2	
109840	23	
110985	202	
111279	13	
111668	544	
112314	1000	

54
111916

9/18/12
54

(42)

July 30, 2009 8:31:15 AM

Shop Packet Print

Page 2

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AN960JD8  Washer	+24	Purchased	No			120	Each	1,077.000	96.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1077
107091	9
108335	11
110382	48
110917	3
111578	506
112314	500

111578 SP

D2143RevC1



Hinge Bracket

Manufactured No

120 Each 33.0000 4.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	33
37739	33

37739

9/8/12 (4x) SP

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S +4 D2144RevD Hinge Bracket	+1	Manufactured	No			120	Each	18.0000	4.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

18

41174

18

41174 SC

S +4 D2150RevA Packer Doubler, Hinge	x2	Manufactured	No			120	Each	24.0000	8.0000			
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Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

24

45813

24

45813 SC

S +4 D2151RevB Packer Doubler, Hinge	x2	Manufactured	No			120	Each	5.0000	8.0000			
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Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5

44889

5

(5x) 44889 9/8/12 (4x) SC

B51407
9/8/12
(x3)
SC

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Dart Aerospace Ltd

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2153RevA1		Manufactured	No			120	Each	48.0000	4.0000			



Door Prop

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

48

21572

0

45058

12

48373

36

120

Each

33.0000

4.0000

D2154RevC



Stud Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

33

44890

19

45814

14

45058 54

45814 7/8/12 SP

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Shop Packet Print

Page 5

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2237RevD1	42	Manufactured	No			120	Each	46.0000	8.0000			



Striker Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

12

46162

12

Main Warehouse

ST022

34

50348

34

D2461RevA H @ 87" long

Manufactured No

120

f

170.7040

30.5263



Neoprene "D" Seal

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

170.704

34304

14.234

39782

156.47

46162 1 sh

50348 7 sp

39782 9/6/13
5's

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Shop Packet Print

Page 6

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D2463RevA	1 x 87" long	Manufactured	No			120	f	775.3752	29.0000			
-----------	--------------	--------------	----	--	--	-----	---	----------	---------	--	--	--



Seal

-0870

1 x 87" E

7 measured
8/18/13

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 75.3752

25153 0

31350 1.8278

34305 18.25

41121 3.75

43841 51.5474

Main Warehouse

ST404 700

50075 700

D2583RevB 1 x 2

Manufactured No

120 Each

27.0000 8.0000



Latch Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 27

36043 2

48648 25

50075 54

48648

9/18/12 44
54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D2585RevB Mounting Channel	+2	Manufactured	No			120	Each	33.0000	8.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

8

45888

8

Main Warehouse

ST37

25

50544

25

D2586RevD

Door Latch

Manufactured No

120

Each

57.0000

8.0000

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

57

23082

0

45554

1

47183

56

50544

47183

9/18/12 (40) SD

W/O:		WORK ORDER CHANGES					
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D2587RevA1		Manufactured	No			120	Each	57.0000	4.0000			
												
Door Slug, 350 Hinge												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

57

48647

57

D2589RevA

Keys, Key Chain, 350 Hinge

Manufactured No

120

Each

67.0000

4.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

67

46840

27

50378

40

18647 *SP*

46840 9/8/10

(42) Sp

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D2690-17RevB2 Cable	41	Manufactured	No			120	Each	22.0000	4.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

48234

2

Main Warehouse

ST41

20

50666

20

D2857-1RevB

Manufactured

No

120

Each

35.0000

4.0000

Hinge Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

35

41166

7

45788

16

50235

12

48234 (2x) SD

50666 (2x)

45788 ✓ 9/8/12 (4x) SD

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D2857-2RevB	+1	Manufactured	No			120	Each	31.0000	4.0000			
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Hinge Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 31

43363 5

45797 26

D2858-1RevB	+1	Manufactured	No			120	Each	37.0000	4.0000			
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Hinge Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 37

43364 7

45798 30

D2858-2RevB	+1	Manufactured	No			120	Each	29.0000	4.0000			
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Hinge Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 29

41439 8

45799 21

July 30, 2009 8:31:15 AM

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FG-778150-550-ROL

71

Purchased

No

120

sf

1,016.000

4.0000

7781 9oz Glass 50"x125yd

A

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1016

111166

1016

1- cut 1 squarre ft of glass cloth

MS20426AD3-4

112

Purchased

No

120

Each

8,385.000

48.0000

RIVET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8385

104374

4385

110398

4000

MS20470AD4-5

116

Purchased

No

120

Each

3,973.000

72.0000

Rivet, Universal Head

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3973

109031

973

111916

3000

SAD 09-08-27

4

104374 59

109031

9/8/12 4x

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Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L08 *x18* Purchased No

120 Each 162.0000 72.0000



M112492 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	162	
110002	24	
111889	30	
112243	108	

(18x)

51 SP

112243

MS21042L3 *x4* Purchased No

120 Each 3,547.000 16.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	3551	
110844	32	
111274	527	
111668	992	
112314	2000	

(4x)

111274

9/8/12

(4x) SP

Main Warehouse

WA	-4	
111274	-4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 30, 2009 8:31:15 AM

Work Order ID: 51045

Parent Item: D350-588-011RevN/A

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/21/09

Required Date: 7/21/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS27039-08-11 *x2* Purchased No 120 Each 125.0000 8.0000



Screw

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 125

104427 6

108335 19

111977 100

MS27039-1-15 *x2* Purchased No 120 Each 102.0000 8.0000



Screw

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 102

106903 3

108169 4

109321 4

111916 91

2x 111977 ✓ *50*

2x 111916 ✓ *9/8/12 4x 50*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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